

### **Abstract**

The invention relates to a method for improving the metal effects and further processing criteria as well as the flexibility of resin coated decorative papers. When  
5 printing metal effect inks by means of gravure printing, the application of solutions of alkaline metal salts delays hardening of the resin coated decorative papers, which is an improvement. A sodium aluminate solution ( $=\text{NaAlO}_2 \times 0.12\text{Na}_2\text{O} \times 0.3\text{H}_2\text{O}$ ) (water or water/extender mixture) is applied in a gravure press with a fond cylinder or another adequate method onto printed or non-printed standard base paper. The  
10 sodium aluminate is solved in  $> 60^\circ\text{C}$  hot demineralised water (or water in general) in order to produce a mixture in the desired concentration.